

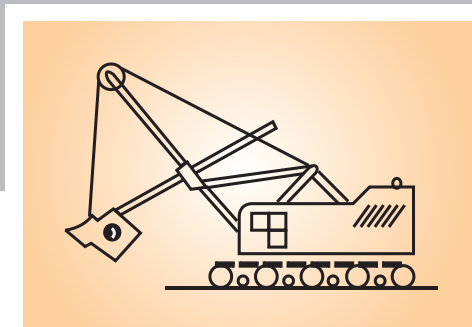
ESSEN[®] HM 35

AC/ DC +

Low alloy steel electrodes For effective surface treatment

AWS A5.1-91E7018

Low Hydrogen Electrode for Radiographic Quality Welding of Steels.



PROPERTIES

A basic low hydrogen electrode containing iron powder in the coating. For welding mild steels in thick sections under conditions of high restraint. Fillet welding of high tensile steels. All positional welding possible.

MECHANICAL PROPERTIES

Tensile Strength (Mpa) => 582 (~ 58 kg / mm²)
 Yield Strength (Mpa) => 478
 Elongation (%) -> 31 Charp V-Notch Impact => 30J at -29°C

APPLICATIONS

Suitable for tough and ductile welds of radiographic quality in boilers, pressure vessels and heavy structures, subjected to dynamic loading and impact. Applications may include penstocks, earthmoving machines, etc.

WELDING PROCEDURE.

RECOMMENDED AMPERAGE	
Size	Current
3.15mm x 350mm	110 - 140 Amps
4.00 mm x 350 mm	135 - 190 Amps

PACKING	
3.15 mm x 350 mm 5 kg	32 pcs/kg (Approx.)
4.00 mm x 350 mm 5 kg	21 pcs/kg (Approx.)



ESSEN
WELDING ALLOYS PVT. LTD.



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PREMIUM WELDING ALLOYS

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